

1 1. A method of forming a security article, comprising the steps of:

2 2 providing a light transmissive substrate having a first surface and an opposing
3 2 second surface, the first surface having an optical interference pattern; and
4 3 forming a color shifting optical coating on the second surface of the substrate,
5 4 the optical coating providing an observable color shift as the angle of incident light or
6 5 viewing angle changes.

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8 2. The method of claim 1, wherein the optical interference pattern is formed by
9 embossing a diffraction grating pattern or a holographic image pattern on the first surface of
10 the substrate.

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12 3. The method of claim 1, wherein the color shifting optical coating is formed by
13 depositing an absorber layer on the second surface of the substrate, depositing a dielectric
14 layer overlying the absorber layer and depositing a reflector layer overlying the dielectric
15 layer.

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18 4. The method of claim 1, wherein the color shifting optical coating is formed by
19 depositing a first absorber layer on the second surface of the substrate, depositing a dielectric
20 layer overlying the absorber layer and depositing a second absorber layer overlying the
21 dielectric layer.

5. The method of claim 1, wherein the color shifting optical coating is formed by
1 applying a color shifting ink comprising a plurality of multilayer color shifting flakes
2 dispersed in a polymeric medium to the second surface of the substrate.

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5 6. The method of claim 1, wherein the color shifting optical coating is formed on the
6 second surface of the substrate by coextruding a color shifting material comprising a plurality
7 of multilayer optical interference flakes dispersed in a polymeric medium, with a material
8 forming the substrate.

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10 11 7. The method of claim 1, further comprising the steps of forming a release layer on
12 the substrate, and of hot stamping the security article to an object.